

Work Order ID 127555 - 1

127555

Page 1

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Item ID: D350-578-011 *SPK 1* Accept *N900040100* Setup Start *NS1*
 Revision ID: *SPK 1* Stop *NS2*
 Item Name: Bearpaw Installation
 Start Date: 12/22/14 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 1/05/15 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: ML3 Date: 14-12-22 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-578	G								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo <i>M. D.</i>	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-578-011 CHG005								
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									

JAN 27 2015 *1* DAS 05 9-09 FEB 02 2015
2x DAS 28 9-09 JAN 28 2015 *2x*
 JAN 27 2015 *1* DAS 05 9-09 FEB 02 2015 *2x*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127555

127555

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Item ID: D350-578-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bearpaw Installation

Stop

NS2

Start Date: 12/22/14 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/05/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

0.00

180

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-011 Location: _____

Ship

DAS
06
9-09

FEB 02 2015

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ

15-02-02

MF

15-2-2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 1

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Work Order ID: 127555

127555

Parent Item: D350-578-011

D350-578-011

Parent Item Name: Bearpaw Installation

Start Date: 12/22/14

Required Date: 1/05/15

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A New Issue 07-01-02 JLM

IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC

IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B *D2182B* Seal(\$Per Foot) DAS 06 9-89		Manufactured	No			160	f	171.0000	2.5 **	5	DAS 28 9-89	DAS 46 JAN 2 1 2015 9-89	
				<u>Location</u>				<u>Loc Qty</u>					
				ST411				171					
				115189				171		5			
D2274 *D2274* Radius Block DAS 06 9-89		Manufactured	No			160	Each	524.0000	12 **	24		DAS 28 9-89	DAS 46 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				FG				12					
				86855				12					
				ST012a				512					
				121589				299		24			
				124363				213					
D2529 *D2529* Washer DAS 06 9-89		Manufactured	No			160	Each	191.0000	12 **	24		DAS 28 9-89	DAS 46 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST007				191					
				119633				191		127909 11 x 13			

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 127555

127555

Parent Item: D350-578-011

D350-578-011

Parent Item Name: Bearpaw Installation

Start Date: 12/22/14

Required Date: 1/05/15

Start Qty: 2.00

Required Qty: 2.00

D2438

Manufactured No

160

Each

44.0000

6

12

D2438

Clamp

DAS
06
9-89

Location

Loc Qty

Loc Code

ST542

44

124377

44

DAS
28
9-89

JAN 21 2015
DAS
46
9-89

127588

D2432

Manufactured No

160

Each

0.0000

2

4

D2432

Bearpaw 19" X 24"

DAS
06
9-89

Location

Loc Qty

Loc Code

ST343

75

M128813

12

M129909

63

DAS
28
9-89

DAS
46
9-89

128/32 X1
128/313 X1

AN4-17A

Purchased No

160

Each

75.0000

12

24

AN4-17A

Bolt

DAS
06
9-89

NAS1149D0463J

Purchased No

160

Each

6,559.000

24

48

NAS1149D0463J

WASHER

DAS
06
9-89

DAS
46
9-89

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

1155

M129390

1155

ST269

4599

M129390

12

M130799

4587

DAS
28
9-89

DAS
46
9-89

131139

48

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Offset/Setup									
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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 127555

127555

Parent Item: D350-578-011

D350-578-011

Parent Item Name: Bearpaw Installation

Start Date: 12/22/14

Required Date: 1/05/15

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

160

Each

3,672.000

12

24

MS21042L4

Locknut--

DAS
46
9-89

**

DAS
28
9-89

JAN 21 2015

DAS
46
9-89

DAS
86
1-89

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

704

m127813

704

ST260a

2000

m130799

2000

ST305

926

426

426

m130922

500

24

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
☐ Bending	☐ Bend	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Hardware	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Burrs	☐ Inspection Incomplete/Unqualified	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Instructions Incomplete/Unclear	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Misaligned/off center	☐ Positioned Wrong
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Power Loss/Surge
☐ Inspection Strip in Tube	☐ Drawing	☐ Misread	☐ Pressure/Forced
☐ Marks/Chatter	☐ Drill Holes	☐ Off-set	☐ Set-up
☐ Turning Sequence	☐ Finish	☐ Out of Calibration	☐ Temperature/Cure
☐ Wave/Twist in Tube	☐ Fit/Function	☐ Out of Sequence	☐ Weld
			☐ Wrong Stock Pulled
			☐ Other

FEB 02 2015

5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -021	Qty -031	Part Number	Description
X						D350-578-011	BEARPAW INSTALLATION
	X					D350-578-013	BEARPAW INSTALLATION
		X				D350-578-015	BEARPAW INSTALLATION
			X			D350-578-017	BEARPAW INSTALLATION
				X		D350-578-021	BEARPAW INSTALLATION
					X	D350-578-031	WEARPLATE KIT
6	6			6		D2182B050	Rubber Cushion
12	12	12	12	12		D2274	Radius Block
12	12	12	12	12		D2529	Washer
6	6			6		D2438	Clamp
2						D2432F	Bearpaw
		2				D2432-3	Bearpaw
				2		D2672F	Bearpaw
					2	D3859-041	Wearplate
		6	6			D4011-1	Clamp
		6	6			D4012-1	Cushion
	2					D4297-1	Bearpaw
			2			D4297-3	Bearpaw
12	12			12	12	AN4-17A	Bolt
	12	12	12			AN4-20A	Bolt
24	12	12	12	24	12	NAS1149D0463J	Washer
12	12	12	12	12	12	MS21042L4	Nut (or MS21042-4)